

Date: Wednesday, 4/4/2007 9:14:36 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BASKET (A119) STRUT  
 Job Number : 31628  
 Estimate Number : 12436  
 P.O. Number : N/A Part Number : D35171  
 This Issue : 4/4/2007 S.O. No. : N/A Drawing Number : D3517 PRELIMINARY Rev. A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : R & D SM/MED FAB Drawing Revision : A PRELIMINARY A EC 07.04.09  
 Previous Run : 29574 Material : N/A  
 Due Date : 4/30/2007 Qty: 10 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : EST rev. A 05.06.06 preliminary EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0750X04000 6061-T6 Bar .75" x 4.0"



Comment: Qty.: 0.6999 f(s)/Unit Total : 6.9993 f(s) 7.6992

6061-T6 Bar .75" x 4.0"

Batch: M101283

ml 07 04 18

(11)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3517

Dwg Rev: A

Prog Rev: A

ml 07 04 19 (11)

2-Open holes to finish size as per Dwg D3517 ml 07 04 19

(11)

3-Deburr if necessary

ml 07 04 19 (11)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



ml 07 04 19

(11)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



07.04.24 (11)

Comment: SECOND CHECK

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(11X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ml 07/04/24

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   R   Date:   Nov 27  

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Wednesday, 4/4/2007 9:14:36 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET (A119) STRUT

Job Number: 31628

Part Number: D35171

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M103706



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

HL

07-04-24

(11)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(11X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L

07/04/25

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 212

SP

7/4/26

50

(11)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(11)

Comment: FINAL INSPECTION/W/O RELEASE

07/04/27

Job Completion



W 07-04-27

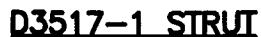
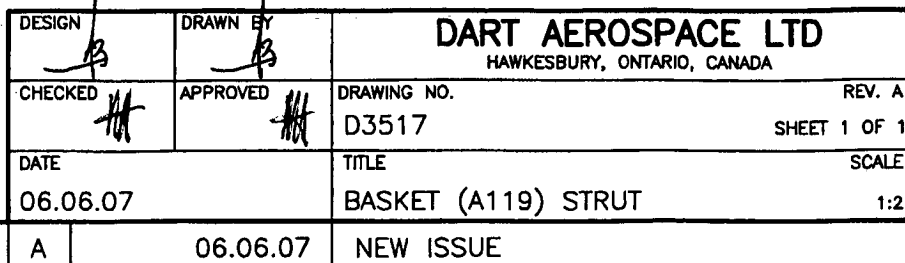
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



- 1) MATERIAL: M6061-T6 (OR 6061-T6510/T6511/T6512/T62) ALUMINUM BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF DART MATERIAL SPEC M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) IDENTIFY WITH DART P/N D3517-1 USING FINE POINT PERMANENT INK MARKER
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY  
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 WITHOUT NOTICE  
 WORK ORDER  
 NO. \_\_\_\_\_

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|                                  |  |                      |
|----------------------------------|--|----------------------|
| DART AEROSPACE LTD               |  | Work Order: 31628    |
| Description: BASKET (A119) strut |  | Part Number: D3517-1 |
| Inspection Dwg: D3517 Rev: A     |  | Page 1 of 1          |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Inspection Sheet<br>Drawing Dimension | Tolerance    | Actual<br>Dimension | Accept | Reject | Method of<br>Inspection | Comments |
|---------------------------------------|--------------|---------------------|--------|--------|-------------------------|----------|
| A 6.74                                | +/-0.030     | 6.742               | ✓      |        | VERN                    |          |
| B 6.122                               | +/-0.010     | 6.122               | ✓      |        | VERN                    |          |
| C 7.817                               | +/-0.010     | 7.824               | ✓      |        | VERN                    |          |
| D 3.750                               | +/-0.010     | 3.754               | ✓      |        | VERN                    |          |
| E 0.75                                | +/-0.030     | 0.75                | ✓      |        | VERN                    |          |
| F Ø 0.257                             | +0.006-0.001 | 0.257               | ✓      |        | VERN                    |          |
| G                                     |              |                     |        |        |                         |          |
| H                                     |              |                     |        |        |                         |          |
| I                                     |              |                     |        |        |                         |          |
| J                                     |              |                     |        |        |                         |          |
| K                                     |              |                     |        |        |                         |          |
| L                                     |              |                     |        |        |                         |          |
| M                                     |              |                     |        |        |                         |          |
| N                                     |              |                     |        |        |                         |          |
| O                                     |              |                     |        |        |                         |          |
| P                                     |              |                     |        |        |                         |          |
| Q                                     |              |                     |        |        |                         |          |
| R                                     |              |                     |        |        |                         |          |
| S                                     |              |                     |        |        |                         |          |
| T                                     |              |                     |        |        |                         |          |
| U                                     |              |                     |        |        |                         |          |
| V                                     |              |                     |        |        |                         |          |
| W                                     |              |                     |        |        |                         |          |
| X                                     |              |                     |        |        |                         |          |
| Y                                     |              |                     |        |        |                         |          |

|                        |                                |                     |            |
|------------------------|--------------------------------|---------------------|------------|
| Measured by: <i>MM</i> | Audited by: <i>[Signature]</i> | Prototype Approval: | N/A        |
| Date: 07 04 19         | Date: 07 04 24                 | Date:               | N/A        |
| Rev                    | Date                           | Change              | Revised by |
|                        |                                | New Issue           | KJ/RF      |
|                        |                                |                     | Approved   |

*[Signature]*